Work Orde October 13, 2011				*748	70*							Page 1
Revision ID:	D3286-3 Spacer		· · · · · · · · · · · · · · · · · · ·	Accept	*N900	040	100)* 5	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	10/13/11 10/27/11	Start Qty: 80.00 Req'd Qty: 80.00	*80* *80*		Cust Item II Customer:	D:						
Approvals:	Process Pl	an: M.L. J	Date: 11 10 14	Tooling:	Da	ıte:	_	.]		Start	*NI	⊋ 1*
••	QC:	-	Date:	SPC (Y/N):	Da	nte:				Stop	*NI	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr										
D3286	Re	v A								,		
*100 *100* Hardinge Hardinge CNC Lather	e Small		SMALL as per Folio FA434 and Dw er Dwg D3286	0.00 0.00 g D3286				80	_	<i>b</i> _ <i>c</i>	m/	1/11/10/
110		QC2- Inspect parts off m		0.00				80	6	<i>*</i>	and	100
110 QC Quality Control		Мето		0.00				<u> </u>			<u>'</u>	X
120		QC8- Inspect parts - seco	and check	0.00	- 11/10/24			8 0		d		
120 QC Quality Control		Memo		0.00	a 11/10/24				- <u>'</u>	7		

Dart Aerospace Ltd

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W/O:			V	VORK OR	DER CHANG	GES					
DATE	STEP	PROC	EDURE CH	HANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				<u> </u>							
Part No	•	PAR #:	_ Fault Ca	itegory:		NCI	R: Yes I	No DQ	A:	Date: _	
	Re	esolution:	Disposit	tion:		QA	: N/C Clo	sed:		Date: _	<u>-</u>
NCR:		W	ORK OR	DER NON	-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC	Initial	Corrective		ction B	Sign & Verification			Approval	
		Section A	Chief Eng						on C	Chief Eng	QC Inspector
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		- -	-						-		
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Work Order ID 74870 *74870* Page 2 October 13, 2011 10:36:24 AM Accept *N900040100* Item ID: D3286-3 Setup Start **Revision ID:** Item Name: Spacer *80* **Start Oty: 80.00 Start Date:** 10/13/11 **Cust Item ID:** Required Date: 10/27/11 Req'd Qty: 80.00 *80* **Customer:** Reference: Run Process Plan: Date: Tooling: Date: Approvals: QC: Date: SPC (Y/N): Date: Tool # Plan Reject Reject Insp. Sequence ID/ Operation Set Up/ Tool ID Accept Code Qty Qty Work Center ID Description Number Stamp **Run Hours** Identify as per dwg & Stock Location: ST 11.5 0.00 130 *130* 0.00 Packaging Memo ***STOCK IN SKIDTUBE CELL*** Packaging QC21- Final Inspection - Work Order Release 140 0.00 *140*

0.00

Memo

Quality Control

Q1/10-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	·	PAR #:	Fault Cat	tegory:	_ NCR: Ye	s No	DQA:	_ Date: _		
	R	esolution:	Disposit	on:	_ QA: N/C	Closed	d:	Date: _		
NCR:	, *	V	VORK ORI	DER NON-CONFORMA	NCE (NC	R)		,		
DATE	STEP	Description of NC		Corrective Action Section			/erification	Approval	Approval	
DA. L	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		Section C	Chief Eng	QC Inspector	
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Picklist Print

October 13, 2011 10:36:28 AM

Work Order ID: 74870

74870

Parent Item:

D3286-3

D3286-3

Parent Item Name: Spacer

Start Date: 10/13/11

Required Date: 10/27/11

Page 1

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP A04.07.14New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			110	f	365.5211	0.3417	28.77474	OM	4/	/
M304TR	0.500W	049							**	79.0	4/	41	11/10/24

304 RD Tube .500 x .049W

Loc Qty	Loc Code	
365.521058		
2.23		
145.421058		
66.87		
151		29.041
	365.521058 2.23 145.421058 66.87	365.521058 2.23 145.421058 66.87

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	iES				
DATE	STEP	PRO	CEDURE CH	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	egory:	NCR: Ye	s No D	QA:	Date: _	
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NCR:	ļ	\	WORK ORE	ER NON-CONFORM	ANCE (NO	R)	,		
DATE	STEP	Description of NC			tion B		ification	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		ection C	Chief Eng	QC Inspector
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								,* 	
								<i>3</i>	
1									
					* 4.				

DART AEROSPACE LTD	Work Order:	74870
Description: Spacer	Part Number:	D3286-3
Inspection Dwg: D3286 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		First Arti		_	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		omments
4.000	+/-0.010	3.999			56.08		
0.500	+/-0.010	0.500			51.08		
							11-
	t took t			,			
	· ·						
	. •						
-							
			•				
leasured by:	11/20	Audited by:	b.a		Prototype A	pproval:	N/A
	11/10/24	Date:	11/10/24	4		Date:	N/A
			- ' - -				
ev Date A 04.09.01	Change New Issue					Revised by	Approve

Dart A	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES		7		
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
								Prod Mgr	QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA :	:	Date:	
	R	esolution:	Dispositio	on:	QA: N/C CIO	osed:		Date: _	
NCR:		V	NORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC			1/0-				
	O'L'	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC inspector
									1 1
NOTE: Da	to & initia	al all entries							

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	DESIGN	DRAWN BY	DART	AEROSPAC		INC.
	CHECKED.	APPROVED	DRAWING NO. D3286		SH	REV. A EET 1 OF 2
-	DATE		TITLE			SCALE
	04.05.06		GROUND	HANDLING PAR	RTS	1:1
				. —		

04.05.06 | NEW ISSUE A 5.374 -- 3.974 -0.700 R0.250 (TYP) ·R0.430 (TYP) 0.500 1.000 2.000 FLAT PATTERN 1.000 R0.250 0.250 (TYP) (TYP) Ø0.188 1.763 -(2 PLACES) 1.150 (TYP) - 1.806 INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL. BENDING DETAIL SHOP COPY R1.51 RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK

(REF DART SPEC. M304S11GA) BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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NO_ 34870 M.C.J

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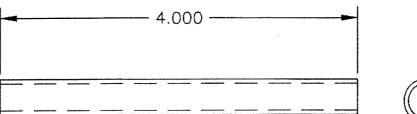
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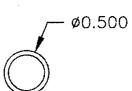
W/O:			W	ORK ORDER CHANG	GES				44	
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	gory:	_ NCF	R: Yes N	lo DQA		Date:	
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DATE	STEP	Description of NC		Corrective Action Section B			Verification Appro			al Approval
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NOTE: Da	ate & initia	al all entries								

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DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHECKED;	APPROVED,	DRAWING NO.		REV. A
 ₩	1 #	D3286		SHEET 2 OF 2
DATE		TITLE		SCALE
04.05.06		GROUND I	HANDLING PARTS	1:1





D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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W/O:			WORK ORDER CHANGES				A STATE OF THE STA		**		
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NCR:				R NON-CONFORM					719.		
		Description of NC	Description of NC Corrective Action		ection B	В					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector	
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